

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016078**Date Inspected:** 05-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

- A). Field Splice E1/E2
- B). Field Splice W1/W2
- C). Field Splice W3/W4

A). Field Splice E1/E2

The QAI observed the Complete Joint Penetration (CJP) groove welding on the field splice identified as 1E-2E-A-S4 performed by Xiao Jian Wan, ID-9677, utilizing the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0. The WPS was also used by the Quality Control (QC) Inspector John Pagliero to monitor the in process welding and verify the Direct Current Electrode Positive (DCEP) welding parameters which verified and recorded as 122 amps by the QAI.

Later in the shift the QAI observed the excavation of the CJP from the "B" face side of the weld joint. At the conclusion of the excavation and machining of the excavated surfaces the QC inspector James Cunningham performed the Magnetic Particle Testing (MPT) and no rejectable indications were noted. The testing was conducted utilizing the inspection procedure identified as SE-MT-CT-D1.5-101 Rev. 4. At this time the welder commence the CJP welding from the "B" face of the weld joint. The in process weld inspection and verification of the DC welding parameters were performed by the QC inspector, Mr. Pagliero.

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

The minimum preheat of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius appeared to comply with the contract documents during the CJP welding. The contractor elected to utilize propane fuel to apply heat to the base metal in lieu of using resistance heating bands for the entire length of the weld. The welding was performed in the vertical (3G) position with the work placed in an approximately vertical plane and the groove approximately vertical.

The QAI also observed the welder James Zhen correcting the excessive root opening (12mm), by welding, utilizing the Shielded Metal Arc Welding (SMAW) as per the WPS identified as ABF-WPS-D15-1012-3, Rev.0. The in process weld inspection was performed by Mr. Pagliero utilizing the WPS to perform the weld inspection. The QC inspector verified the welding parameters and were observed and recorded by the QAI as 123 amps. The minimum preheat of 100 degrees Celsius and the interpass temperature of 230 degrees Celsius appeared to comply with the contract documents. The electrodes were stored in electrically heated, thermostatically controlled ovens after removal from sealed containers. The exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 120 degrees Celsius appeared to be in compliance with the contract documents.

Issues

The contractor did not maintain the continuous uninterrupted preheat on two separate occasions. The first incident occurred at the lunch break from 1200 to 1230. At the beginning of the break the preheat was measured at 100 degrees Celsius and at the conclusion of the break the surface temperature was measured and observed as below 60 degrees Celsius. The second incident occurred at the conclusion of the shift and no attempt was made by the welding personnel to maintain continuous preheat during the interruption of the welding operation. Tempilstik Temperature Indicators were utilized to verify the surface temperatures. The QAI has generated an incident report regarding this preheat issue.

B). Field Splice W1/W2

The QAI observed Tom Pasqualone perform Ultrasonic Testing (UT) of the repairs on the bottom plate field splice identified as WN: 3W-4W-D1. The testing was performed by the QC technician utilizing the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4. The QC technician performed the required shear wave technique during the testing for weld soundness which was performed utilizing a .75 x .75 rectangular transducer. The ultrasonic testing of the repairs was not completed during this shift.

C). Field Splice W3/W4

The QAI observed the continued excavation of the unacceptable discontinuities discovered during the Ultrasonic Testing (UT) of bottom plate field splice identified as 3W-4W-D1. The excavations were performed by welding personnel Fred Kaddu ID-2188 utilizing a high cycle grinder to excavate and remove the defects. At the conclusion of the excavations the QC technician William Sherwood performed a Magnetic Particle Test (MPT) of the excavated areas and no rejectable indications were noted. The application and evaluation of the MPT appeared to comply with the MPT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The repair welding was performed utilizing the Shielded Metal Arc Welding (SMAW) process and the 3.2mm electrode as per the Welding Procedure

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Specification (WPS) identified as ABF-WPS-1000 Repair Rev. 2. The WPS was also used by the QC inspector, Mr. Sherwood, as a reference to monitor and verify the Direct Current welding parameters which were noted as 138 amps. The welding was performed in the flat (1G) position with the work approximately in the horizontal plane and the weld metal deposited from the upper side. The minimum preheat temperature of 60 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius was monitored and maintained by the QC inspector during the repair welding.

QA Observation and Verification Summary

The QA inspector observed the QC activities and the welding of the field splices utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspector and utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The ESAB consumables utilized for the SMAW process appeared to comply with the AWS Specification and AWS Classification. The QC inspection, testing and welding performed on this shift appeared to be in general compliance with the contract documents. At random intervals, the QAI verified the QC inspection, testing, welding parameters and the surface temperatures utilizing various inspection equipment and gages which included a Fluke 337 Clamp Meter and Tempilstik Temperature indicators.

The QAI continued the review and verification of the multi-pass fillet welds of the floor beam web to skin plate at the Orthotropic Box Girder (OBG) suspender brackets located at various areas as noted on the Request for Information (RFI) document identified as ABF-RFI-00611R00. The QAI performed a visual observation to verify that the fillet welds along girder Face "B", for 1100mm from the OBG corner on girder Face "A", and for 800mm from the OBG corner on girder Face "C" comply with the RFI. At the conclusion of the QAI verification no issues were noted on the OBG Lift W4, PP24, PP26 and PP28. No issues were observed.

The digital photographs below illustrate the work observed during this scheduled shift.



Summary of Conversations:

There were general conversations with Quality Control Inspector Mike Johnson at the start of the shift regarding the location of American Bridge/Fluor welding personnel and inspection/ N.D.E. testing scheduled for this shift.

The QAI discussed the preheating of the 30 mm and the 35 mm, 485W longitudinal field splice plates located at

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

the "A" deck splices identified as 1W-2W-A-S1 through S6, with Quality Control Inspector Mike Johnson. During our conversation Mr. Johnson informed the QAI that the continuous preheat requirements would not be performed or exercised during the CJP welding of the plate splices and that the Contractor's upper management has decided that the preheat requirements of the Special Provisions Specification does not apply to the welding operation of these plate splices.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
